



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

#1

D206-667-103
Job Sheet 182675



Part No: D206-667-103

Job Qty: 1 ea

Part Name: Fwd Crosstube - High 206L / L1 / L3 / L4



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/29/18

Job Tracking No:

Due Date: 9/21/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG DSI9565 REV A , DSI9628 REV A , D206-667-143 REV C (DEO) IPP Rev:F 05.09.01 Add holes for compatibility with Bell Skid tubes KJ/JLM IPP Rev:G 08-06-03 update per DSI9415 (ECN1198) DD IPP Rev: H 08.11.17 QC5 was QC6 at step 12 KJ verified: EC IPP Rev:I 08-12-15 add magnobond DD verified:EC IPP Rev J 09.01.06 ECN 08-562 EC verified:DD IPP Rev:K 09-01-19 as per DSI9439 DD verified:EC IPP REV:L 11.08.05 PER ECN 11-615 DD VERF:EC IPP REV:M 12.08.20 DSI9628 revA (ECN12-631) DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	9/21/18	9/21/18	0.00	0.00	Start Up Crosstubes-1		DPL
110	Packaging	1 pcs	9/21/18	9/21/18	0.00	0.00	Packaging1-2		DPL
120	CNC Bend Crosstubes	1 pcs	9/21/18	9/21/18	0.00	3.03	CNC Bend Crosstube		GP DAS 38
130	QC	1 pcs	9/21/18	9/21/18	0.00	0.00	QC15		GP
140	Crosstubes	1 pcs	9/21/18	9/21/18	0.00	0.80	Crosstubes-1		GP
150	HandFXtube	1 pcs	9/21/18	9/21/18	0.00	0.31	HandFinish5		GP
160	QC	1 pcs	9/21/18	9/21/18	0.00	0.00	QC7-1		DPL
170	QC	1 pcs	9/21/18	9/21/18	0.00	0.00	QC5		DPL 18/10/18
180	Outsource	1 pcs	9/21/18	9/21/18			SKY002-VC	P004/267	OCT 09 2018
190	Packaging	1 pcs	9/21/18	9/21/18	0.00	0.00	Packaging2		OCT 09 2018
200	QC	1 pcs	9/21/18	9/21/18	0.00	0.00	QC5		38
210	SprayPaint	1 pcs	9/21/18	9/21/18	0.00	0.25	Spray Paint		AS OCT 11 2018
220	QC	1 pcs	9/21/18	9/21/18	0.00	0.00	QC14		18-10-16
230	Crosstubes	1 pcs	9/21/18	9/21/18	0.00	1.54	Crosstubes-1		18-10-16
240	QC	1 pcs	9/21/18	9/21/18	0.00	0.00	QC5		38
250	Packaging	1 pcs	9/21/18	9/21/18	0.00	0.00	Packaging1-2		OCT 26 2018
260	QC	1 pcs	9/21/18	9/21/18	0.00	0.00	QC4		BB DAS 38
270	Packaging	1 pcs	9/21/18	9/21/18	0.00	0.00	Packaging3-1		BB DAS 38
275	DC	1 pcs	9/21/18	9/21/18	0.00	0.00	DC		DAS OCT 30 2018
280	QC21-FG	1 Ea	9/21/18	9/21/18	0.00	0.00	QC21		21 DAS OCT 30 2018

Part Op 120 - Bend tube as per Dwg D206-667-143 using CNC bender program

Descriptions: 140 - ***** ENSURE PROPER JIG POSITIONING BEFORE DRILLING***** , VERIFIED BY:

***** 1- Drill holes & ream using drill Jig DT8541 & DT8542 as per Dwg D206-667-143. Drill all (3) top holes. Holes facing inboard. ***** ENSURE PROPER JIG POSITIONING BEFORE DRILLING***** , VERIFIED BY: ***** 2- Drill Fwd rivet holes using drill Jig DT8787 fwd as per Dwg D206-667-143. Note: Fwd side has 3x top holes.Facing inboard. 3- C'sink holes as per Dwg D206-667-143. Allow rivet to sit below surface to compensate for paint. 4- Flip tube and switch drilling Jigs from right to left, left to right. Locate Jigs off existing holes using "T" pins .Drill ONLY 2 top holes ONLY plug most bottom holes to prevent accidental drilling. Drill holes and ream using drill Jig DT8541 & DT8542 as per Dwg D206-667-143. Drill only the top (2) holes. 5- Drill Aft rivet holes using drill Jig DT8787 aft as per Dwg D206-667-143. 6- C'sink holes as per Dwg D206-667-147. Allow rivet to sit below surface to compensate for paint. 7- Scribe part # and batch # using vibrating stylus as per Dwg D206-667-143 Inside of Cuff (Do not engrave on outside of tube) 8- *** WEAR LATEX

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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GLOVES WHEN HANDLING CROSSTUBE*** Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-143

150 - ***IMMEDIATELY AFTER GRINDING***

180 - *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE***

190 - *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE***

200 - *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE***

210 - *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** *** MASK AREA UNDER CLAMP PRIOR TO PAINTING AS PER DWG DEO*** 1-Prime inside and outside crosstube as per QSI 005 4.2 2-Paint outside crosstube with White Imron as per QSI 005 4.2 PRIME: 138877 Start Time: _____ Finish Time: _____

PAINT: 138749

220 - Wrap in plastic bag to protect from scratches

230 - 2-Install supports with Proseal 890 per D206-667-143 (DEO) and QSI 015 3-Install supports clamps Using Dt9565 as per Dwg D206-667-143 (DEO), Torque to 80-100 IN-LBS. 4-Install nut plates as per Dwg D206-667-143. Touch-up rivet heads with Imron paint.

240 - ***RE-CHECK TORCQUE ON CLAMP AFTER PROSEAL HAS CURED FOR 72HOURS AS PER DWG.***

VERIFY RESISTANCE PER NOTE 18 AND DWG DEO

260 - ***VERIFY BY _____ BATCH # TO MATCH W/O _____

270 - Identify and pack for shipping as per PPP D206-667-103 Location : FG103

275 - Photocopy bluefile and create labels as per PPP D206-667-103 CHG006

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D206-667-103TRN	Crosstube Turning Detail	1 Ea (1 ea)	90-Start up Operation	158319
D2873-043	Nut Plate Assembly	2 Ea (2 ea)	230-Crosstubes	
D2873-045	Nut Plate Assembly	2 Ea (2 ea)	230-Crosstubes	
D2891-1	Support 2.25	2 Ea (2 ea)	230-Crosstubes	
D3595-063-395	Rubber Cushion 0.63" Wide X 3.95" Long	4 Ea (4 ea)	230-Crosstubes	
MS20601-AD4W8	Rivet	14 Ea (14 ea)	230-Crosstubes	
MS21920-20	Clamp	4 Ea (4 ea)	230-Crosstubes	
AN5-30A	Bolt	4 Ea (4 ea)	250-Packaging	5015691
AN5-32A	Bolt	4 Ea (4 ea)	250-Packaging	5058983-1
AN5-7A	Bolt	10 Ea (10 ea)	250-Packaging	FM123355
AN970-4	Washer	12 Ea (12 ea)	250-Packaging	5016395
D206-667-017	Grounding Strap	1 Ea (1 ea)	250-Packaging	
MS21042L5	Nut	4 Ea (4 ea)	250-Packaging	5099592
NAS1149D0563J	Washer	18 Ea (18 ea)	250-Packaging	5050052

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D206-667-103TRN 5049001	①	4	0
230-Crosstubes	D2873-043 5089003	②	89	0
	D2873-045 5050682	②	23	0
	D2891-1 5037896	②	20	0
	D3595-063-395 5033983	④	139	0
	MS20601-AD4W8 5066728	①④	328	0
	MS21920-20 5034404	4	236	0
250-Packaging	AN5-30A	4	86	0
	AN5-32A	4	357	0
	AN5-7A	10	3,319	0
	AN970-4	12	150	0
	D206-667-017 5049001	①	13	0
	MS21042L5	4	1,054	0
	NAS1149D0563J	18	1,980	0

Part Specifications

Specification

DART
AEROSPACE

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S114797



Part: D206-667-103

Job No: 182675

Serial No/Batch: S114797

Revision:

Inspector:

Exp Date:

Instructions: TC STC SH01-5 Issue 3, FAA STC SR01304NY 05/12/15, JCAB JAI

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

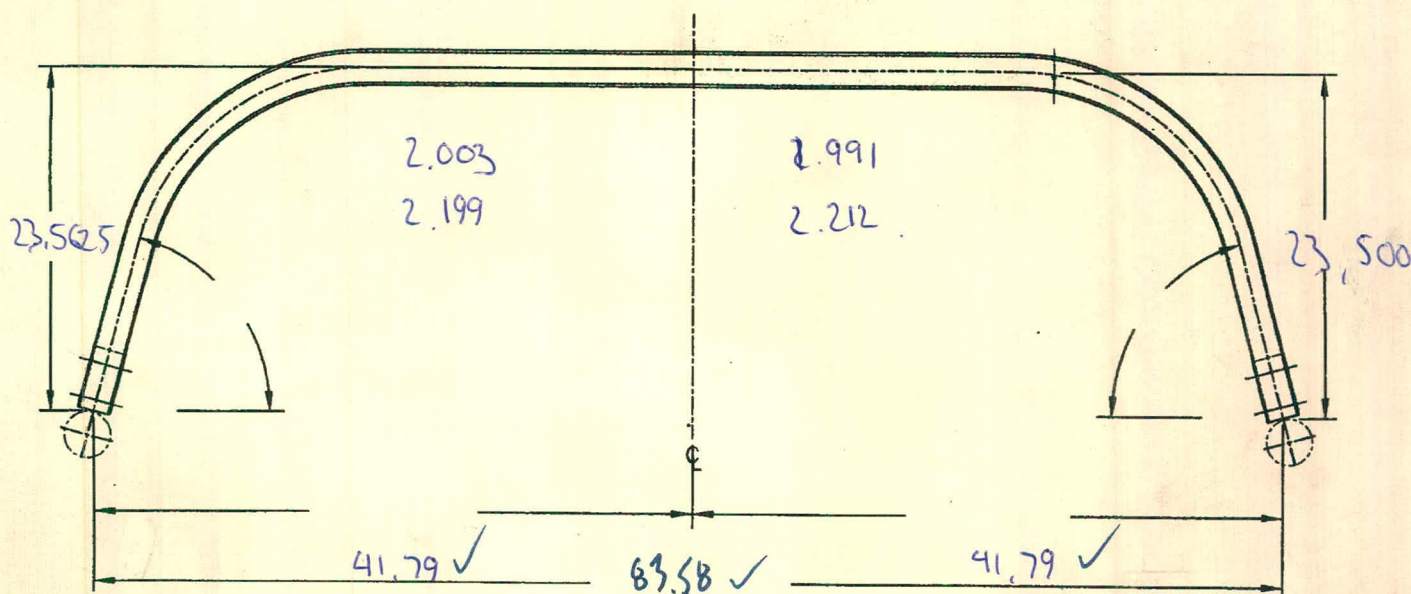
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

DART AEROSPACE LTD		Work Order: 182675
Description: Crosstube High Fwd (206L)		Part Number: D206-667-103
Inspection Dwg: D206-667-143 Rev: C		Page 1 of 1

Required Dimension	Min	Max
Height	23.39	23.65
1/2 Span	41.79	42.05
Angle	54	56
Total Span	83.58	84.10
Bending Passes	10	--
Crushing	--	6%



	Side A	Side B
Bending Passes	10	12
Crushing	4.7%	5.2%
Comments		

QC15 Inspection	EB
Date	18-09-27

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	
B	09.06.26	Dimensions updated per Dwg Rev C	KJ	
C	09.10.22	Minimum height dimension revised	KJ	
D	12.04.16	Added bending, crushing dimensions	KJ	

Item	Qty -143	Part Number	Description
1	X	D206-667-143	CROSSTUBE ASSEMBLY (206L HIGH FWD)
2	1	D6002-115	CROSSTUBE
3	2	D2873-043	NUT PLATE
4	2	D2873-045	NUT PLATE
5	2	D2891-1	SUPPORT
6	4	D3595-063-395	RUBBER CUSHION
7	4	MS21920-20	CLAMP (OR MS21920-21)
8	14	MS20601AD4W8	RIVET (OR NAS9302B-4-8)
9	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6002-115
FINISHED LENGTH = 104.98±0.020
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D206-667-143" AND BATCH NUMBER ON INSIDE OF CUFF USING VIBRATING STYLUS.
- 7) WEIGHT: 15.5 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) RUN CUTTER OFF PART WHERE INDICATED. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 10 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 12) INSTALL D2891-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 13) INSTALL MS21920-20 CLAMPS (OR -21) WITH D3595-063-395 RUBBER CUSHIONS TO SECURE THE D2891-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMP MECHANISMS ARE LOCATED ON CROSSTUBE SUPPORTS.
- 14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 182675465
180829

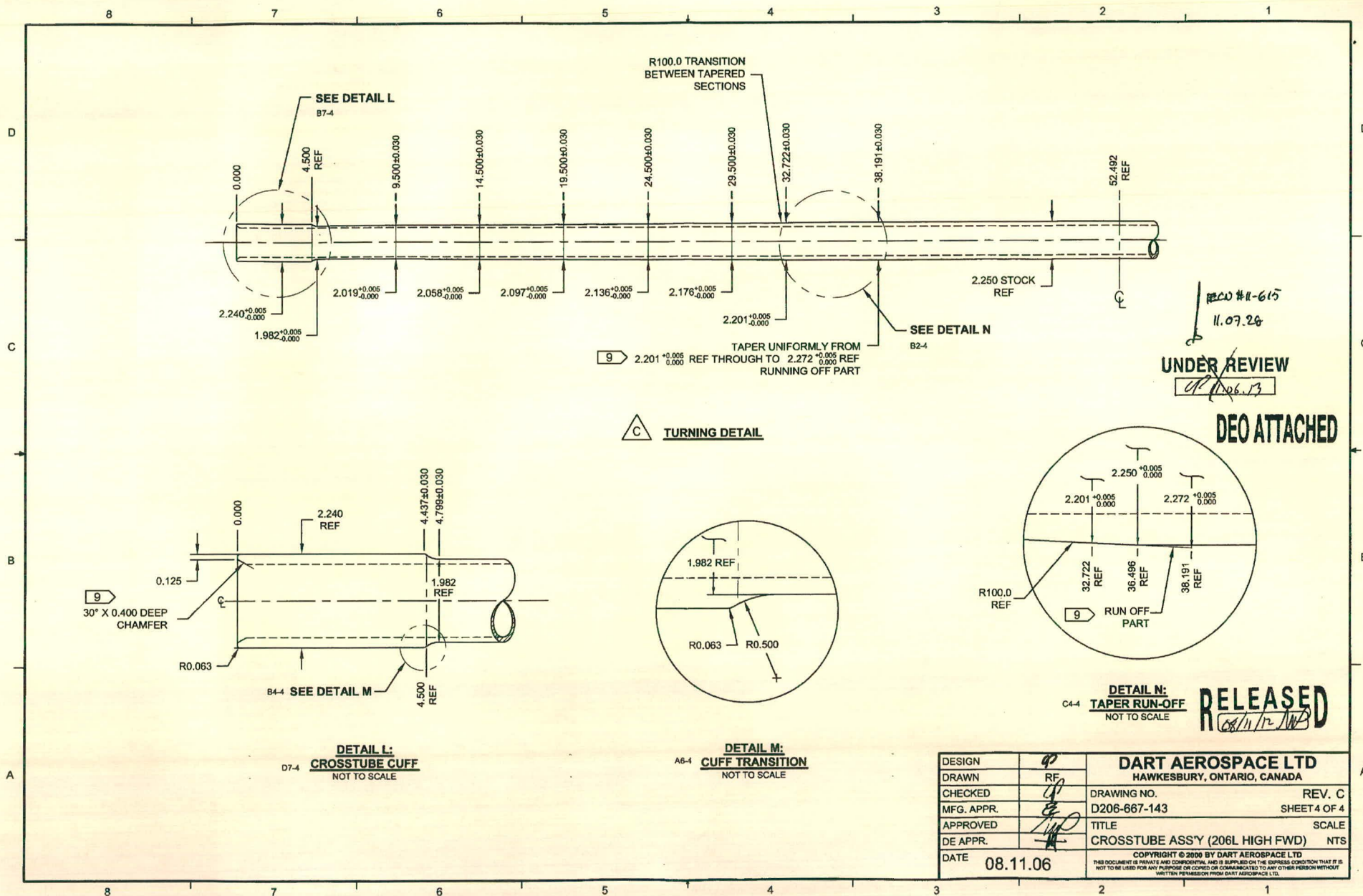
86W #1-615
11.07.28

UNDER REVIEW

08/11/08

DEO ATTACHED RELEASED
08/11/12

C	REVISE GENERAL NOTES/PART LIST (ZN D7-1); REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENT STANDARDS. D3595-063-395 WAS D2856-400-694 (ZN D6-2 & A5-2); REMOVED REF. & ADD TOLERANCE (ZN D3-3, C4-3, C5-3); RELOCATED FLAG #8 (ZN A8-3) PER NCR 210; MOVED TURNING DETAIL & UPDATED TOLERANCE TO SHEET 4.	RF	08.11.06
B	ADD HOLES AND NUT PLATES FOR COMPATABILITY WITH BHT/AA SKUDTUBES	PH	05.07.26
A	NEW ISSUE	CP	00.11.17
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	RF	D206-667-143	SHEET 1 OF 4
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	CROSSTUBE ASS'Y (206L HIGH FWD)	NTS
DATE	08.11.06	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



DRAWING NO. D206-667-143	TITLE CROSSTUBE ASS'Y (206L HIGH FWD)	REV. C	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D206-667-143-C-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>qp</i>	CHECKED <i>ASS</i>	MFG. APPR. <i>[Signature]</i>	APPROVED <i>[Signature]</i>		DE APPR. <i>[Signature]</i>		
DATE 11.07.15	DATE 11.07.20	DATE 11.07.21	DATE 11/07/21		DATE 11.07.21		

PURPOSE:

REPLACE MAGNOBOND WITH PROSEAL.

CHANGE:

IS:

Item	Qty -143	Part Number	Description
9	A/R	PROSEAL 890 B-2	SEALANT, AMS-S-8802 CLASS B-2

WAS:

9	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)
---	-----	----------------	---

NOTE 12 & 15, SHEET 1 IS AMENDED AS FOLLOWS:

IS:

- 12) TO INSTALL D2891-1 SUPPORT: ABRABE MATING SURFACE OF SUPPORT AND CROSSTUBE WITH 180-GRIT SANDPAPER AND REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY A 0.04" TO 0.07" THICK LAYER OF PROSEAL 890 CLASS B-2 (OR AMS-S-8802 CLASS B-2) SEALANT TO MATING SURFACE OF SUPPORT.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING. **PRIOR TO PACKAGING, RE-CHECK TORQUE ON CLAMPS AFTER PROSEAL 890 SEALANT HAS CURED FOR 72 HOURS.**

WAS:

- 12) INSTALL D2891-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

RELEASED
2011-07-28
[Signature]

DRAWING NO. D206-667-143	TITLE CROSSTUBE ASS'Y (206L HIGH FWD)	REV. C	DART AEROSPACE LTD ENGINEERING ORDER	D.E.O. NO. D206-667-143-C-2	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN AJS	CHECKED	MFG. APPR. <i>E</i>	APPROVED <i>AD</i>	DE APPR. <i>AD</i>		
DATE 12.08.02	DATE 12.08.02	DATE 12.08.02	DATE 12.08.02	DATE 12.08.02	DATE 12-08-02	

PURPOSE:

ADD ELECTRICAL GROUNDING STRAP

CHANGE:

PARTS LIST:

ITEM	QTY -143	PART NUMBER	DESCRIPTION
1	X	D206-667-143	CROSSTUBE ASSEMBLY (206L HIGH FWD)
10	2	AN742D36	CLAMP
11	2	MS9165-05	ANGLE BRACKET
12	2	MS21042L3	NUT (OR MS21042-3)
13	2	MS27039-1-08	SCREW
14	4	NAS1149C0332R	WASHER (OR AN960C10L)

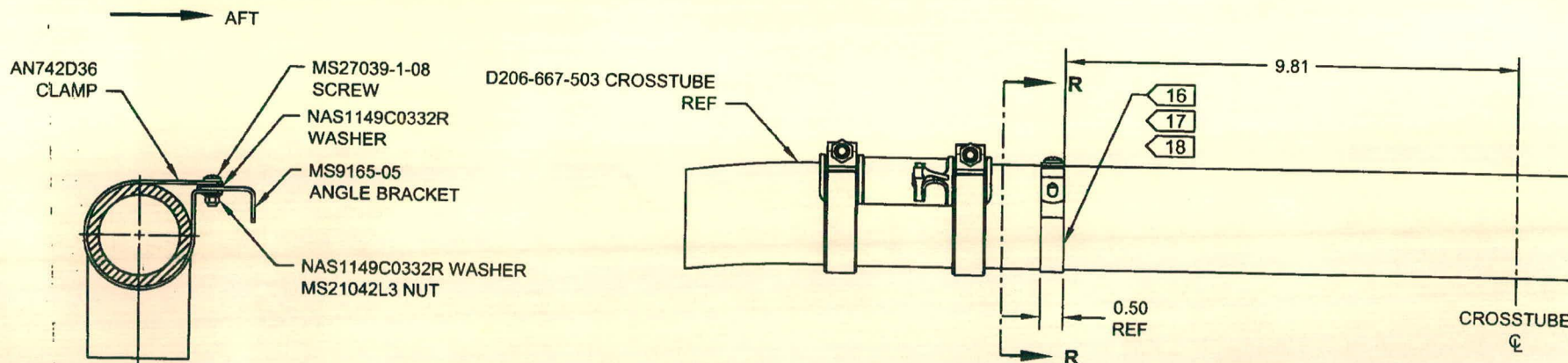
ADD

GENERAL NOTES:

- 16) MASK AREA UNDER CLAMP PRIOR TO PAINTING
- 17) SEAL EDGES WHERE AN742D36 CLAMP MEETS WITH THE CROSSTUBE USING SIKAFLEX-241/-291 OR MIL-S-8802 CLASS B2 OR PROSEAL 890 SEALANT
- 18) PERFORM RESISTANCE CHECK TO ENSURE MAX RESISTANCE IS 10 MILLIOHMS

ADD

RELEASED
CP 12.08.17
ECN 12-631



SECTION R-R

DETAIL P BONDING STRAP INSTALLATION 2 PL

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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041267**

Supplier: SKY002-VC
Skyservice
6120 Midfield Road
Mississauga
ON
L5P 1B1 Canada
Phone: 905-678-5636
Fax: 905-678-5841

PO No: PO041267

PO Date: 10/5/18

Due Date: 10/9/18

Purchase Order
Revision:

Revision Date:

Ship-To Contact: Phone:

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments:

REVISED

E-MAILED
OCT 09 2018

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	181664	D350-748-103	AS350 / AS355 Stainless Steel Fwd Crosstube : TC STC SH06-27 Issue 2, FAA STC SR02359NY 11/03/04, EASA STC EASA.10016903 Revision 2 10/09/03, BRAZIL 2009S04-04 09/04/06 ISSUE P/O TO SKY SERVICE:	Firmed	-	10/8/18	1 pcs	0 pcs	1 pcs	\$142.855714/pcs	\$142.86
	181667			Firmed	-	10/8/18	1 pcs	0 pcs	1 pcs	\$142.855714/pcs	\$142.86
Sub Total:							2	0	2		\$285.71
2	181669	D350-748-203	AS350 / AS355 Stainless Steel Aft Crosstube : TC STC SH06-27 Issue 2, FAA STC SR02359NY 11/03/04, EASA STC EASA.10016903 Revision 2 10/09/03, BRAZIL 2009S04-04 09/04/06 ISSUE P/O TO SKY SERVICE:	Firmed	-	10/8/18	1 pcs	0 pcs	1 pcs	\$142.85714/pcs	\$142.86
	181670			Firmed	-	10/8/18	1 pcs	0 pcs	1 pcs	\$142.85714/pcs	\$142.86
Sub Total:							2	0	2		\$285.71
3	182672	D206-667-103	Fwd Crosstube - High 206L / L1 / L3 / L4 : TC STC SH01-5 Issue 3, FAA STC SR01304NY 05/12/15, JCAB JAPAN STC-32-OSA 02/02/28, EASA STC EASA.IM.R.S.01179 06/07/03, BRAZIL 2009S08-16 09/08/25, BRAZIL 2009S08-17 09/08/25 *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE***	Firmed	-	10/8/18	1 pcs	0 pcs	1 pcs	\$142.85714/pcs	\$142.86



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041267**

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
	182673		<i>1 X</i> OCT 09 2018 <i>[Signature]</i>	Firmed	-	10/8/18	1 pcs	0 pcs	1 pcs	\$142.85714/pcs	\$142.86
Sub Total:							2	0	2		\$285.71
<i>4</i>	182675	D206-667-103	Fwd Crosstube - High 206L / L1 / L3 / L4 : TC STC SH01-5 Issue 3, FAA STC SR01304NY 05/12/15, JCAB JAPAN STC-32-OSA 02/02/28, EASA STC EASA.IM.R.S.01179 06/07/03, BRAZIL 2009S08-16 09/08/25, BRAZIL 2009S08-17 09/08/25 *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE***	Firmed	-	10/8/18	1 pcs	0 pcs	1 pcs	\$142.85714/pcs	\$142.86
							<i>1 X</i> OCT 09 2018 <i>[Signature]</i>				
Grand Total:											\$1,000.00

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Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 10/9/18 11:03 AM dart.lavoie.chantal

140
141
142

**skyservice****Work Order Traveler**
Sky Service F.B.O. Inc.

10105 Ryan Avenue, Dorval, Quebec, H9P 1A2

TCCA AMO 53-89 / EASA 145.7142 / BDA AMO 385

WO #: MWO37683	Customer: Dart Aerospace Ltd.	Dept: NDT YUL	Reference: PO041267 ✓
Descr:	PN:	S/N:	Qty: 1
Make:	Model:	Reg:	A/C S/N:
TSN:	CSN:	TSO:	
Task: UNSCHEDULED			Sequence: 1

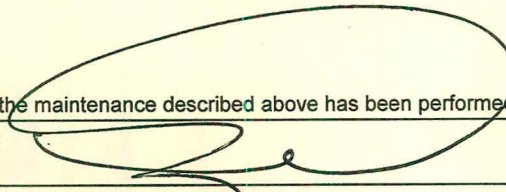
Work Required:**CARRY OUT NDT ON:**

- / 3 FWD CROSSTUBES , P/N# D206-667-103 , J/S# 182672 ✓, 182673 ✓, 182675 ✓
- / 2 STAINLESS STEEL FWD CROSSTUBES , P/N# D350-748-103 , J/S# 181664 ✓, 181667 ✓
- / 2 STAINLESS STEEL AFT CROSSTUBES , P/N# D350-748-203 , J/S# 181669 ✓, 181670 ✓

Action Taken:		Date:	Initial/Stamp:			
LPI C/O IAW ASTM E-1417 REV. 16 ***NO CRACK FOUND*** PEN. ZL-56, MPO13600, CLEANER SKC-S MPO13923 , DEV. MPO11715 , UV LIGHT M-20142		OCT 05 2018	 			
Description	Location	P/N	Qty	Batch	S/N Off	S/N On

DAS
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I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

Signature:	ACA/SCA Stamp	Date:
		OCT 05 2018
Name: RAFIK MELIKIAN		

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86
712

Change Record

PAGE 1 OF 1

Part Number: D206-667-103/-103BL

Description: CROSSTUBE INSTALLATION, 206L/L1/L3/L4 HIGH FWD

[illegible]

